

Date: Wednesday, 7/4/2007 3:45:23 PM  
 User: Eric Charbonneau

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASS'Y
Job Number	: 33301		
Estimate Number	: 12523		
P.O. Number	: N/A	Part Number	: D35313
This Issue	: 7/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32208	Drawing Revision	: N/A
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>4/07-07-12</u>	Due Date	: 7/11/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 06-09.06 EC		

**PROTOTYPE**

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.1379 sf(s)/Unit Total: 0.1379 sf(s)

6061-T6 .040 Sheet

(M6061T6S040): 100742

Batch: M 103321 1B 07-07-06

CERTIFICATE OF CONFORMITY  
 REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: PRELProg Rev: PREL(PTD) →

2-Deburr if necessary

1B07-07-06WF07-07-07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 07-07-06

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EP07/07/10(21)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

1B 07-07-10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PA Date: 07/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>33301</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/10	# 2.0	1 part SCRAP. <del>Part</del> wrong mat used (0.050" instead of 0.040")  R.C. Human Error	<u>07/07/10</u>	SCRAP and Destroy with correct mat. - Remind Employee to be more cautious when pulling mat.  BATCH # <u>102723</u>	<u>07-07-10</u>	<u>En</u> <u>07/07/10</u>	<u>07/07/10</u>	<u>En</u> <u>07/07/10</u>
				<u>M100742</u>				

NOTE: Date & initial all entries

Date: Wednesday, 7/4/2007 3:45:23 PM  
User: Eric Charbonneau

## Process Sheet

Customer: OU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 33301

Part Number: D35313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

SB 07/07/11 ①

7.0

QC5

FAI NEEDS MORE  
DIMS. BENT  
PART OK  
CB 07.07.11

INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**



07/07/11

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

07.07.19

11.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

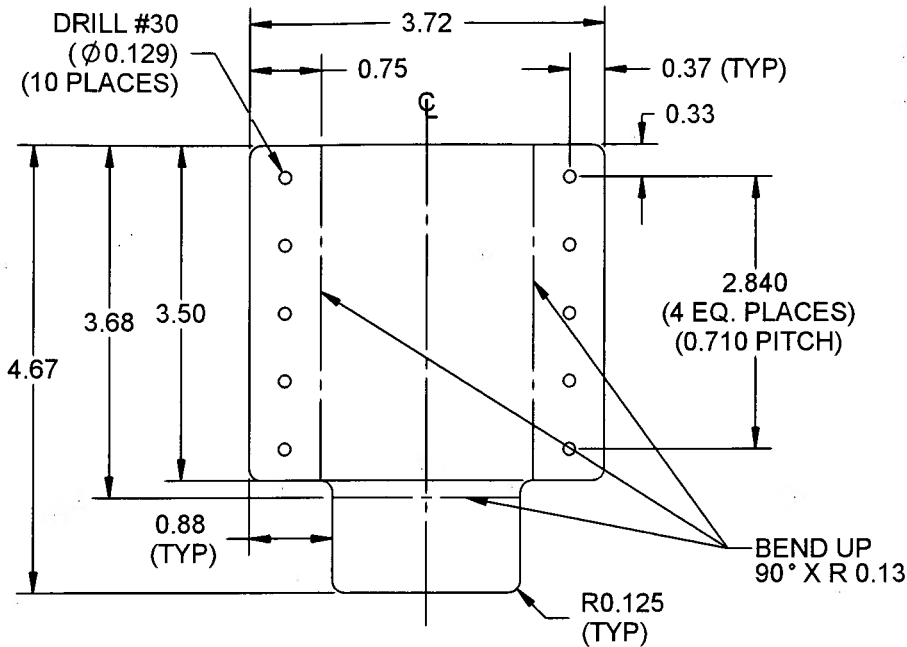
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



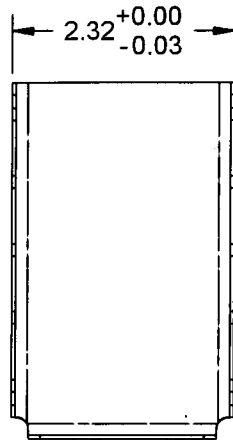
07/07/11

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED	DRAWING NO. <b>D3531</b>	REV. A SHEET 3 OF 3
DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:2



**D3531-3F FLAT PATTERN**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
**CE 07.06.22**



**D3531-3 BRACKET FRONT PLATE**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$



# Receiving Report

Date: April 21/06  
 Supplier: Copper & Brass

Batch No: 1100742  
 Dart P/O: 1005

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☐  
 Shipment Complete: Yes ☐ No ☒  
 Q.C. Inspection ☐

Discrepancies		Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
Part No	Description					
MS0524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0250		12	10	0	2	

TSR No: \_\_\_\_\_

Initials of receiver (if shipment OK) [Signature]

Production/Admin:

Date:

Received/Costing:

Initial:

FORM 000001 (Form 1) Purchase/RECREPORT rev B

Accounting:

Date:

AP/MR:

Initial:

DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
PLEASE REMIT IN CANADIAN FUNDS	GST/HST			9.66

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH. PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

TOTAL \$

147.73

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

10294	SHIP DATE 04/24/06 SHP	GROSS WEIGHT	QUOTE 30-161074-1	0 OF 10		<b>PACKING LIST</b>	
ART AEROSPACE		WORK ORDER ***	ORDER DATE 04/13/06 ORD	TEST RESULTS			
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA		01	DELIVERY DATE 04/24/06 DEL	SHIP BRANCH 30(04)	SELL BRANCH 30-TOR	WORK ORDER <b>UZ3809</b>	
K6A 1K7		6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y					
Copper and Brass Sales Canada		A ThyssenKrupp Materials NA company					
ThyssenKrupp		CUSTOMER SIGNATURE: _____ DATE: _____					
QUANTITY		ORDERED		SHIPPED			
INVENTORY		54.19 LB		52.00			
BILLING		2.00 PC		2.00			
SHIP VIA		SHIPPING STATUS		WAREHOUSE			
COMPLETE X		PARTIAL		CANCEL			
CUSTOMER COMMON/FRT-CCX		FOB DEST		PACKED WITH OTHER GOODS UZ3800			
FINISHING PPD		FINISHED GOODS LOCATION		WARN LABEL:1001			

PART DESCRIPTION 063496-4

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144  
DART AEROSPACE, NO PROCESSING - 48" X 144" Mill  
Dimensions., Test Results Attn to: QA Department.  
SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL  
REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

SPECIAL INSTRUCTIONS  
Shipping, do not place any packages or goods on top of our material."

SCRAP	FILLED BY SC	PACKED BY	Q/A AUDIT
MAX SKID WEIGHT 100	LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK	MAXIMUM BUNDLE WEIGHT 200	
SAKS	CASES	CUSHP	PKGS
SKIDS	BOLS	TUBES	CTNS
FLAT	COILS		
INSPECTION RECORD			

# TEST RESULTS -----

CERTIFICATE OF COMPLIANCE  
We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.  
The products we distribute are not hazardous in their received state. For MSDS sheets go to [www.copperandbrass.com/msds](http://www.copperandbrass.com/msds)  
244-233-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027	ASTM-B209	ROHS COMPLIANT
QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS : TAG NO
52.00 LB CORUS	0CC1837 7124901	